

IN THE CLAIMS

1. (Withdrawn) A y-shaped gusset structure, made from hollow sections, of a support frame for vehicles

wherein

the gusset structure comprises two hollow sections, of which the first hollow section comprises at least one flat side and along its circumference has been cut through except for a web situated in the flat side, and has been bent open around this web, and in that the face of the second hollow section has been inserted into the facing ends of the first hollow section, which facing ends have been created by the process of cutting and bending-open, wherein the edge regions of the first hollow section are integrally connected with the second hollow section.

2. (Withdrawn) The gusset structure according to claim 1,

wherein

the contours of the two hollow sections are adjacent to each other as far as possible without any gap.

3. (Withdrawn) The gusset structure according to claim 1,

wherein

the facing ends of the first hollow section comprise protruding edge regions which adjoin the second hollow section.

4. (Withdrawn) The gusset structure according to claim 1.

wherein

on the sides adjoining the flat side, at the positions where the first hollow section has been cut, in each instance an essentially rectangular strip has been cut out symmetrically in relation to the separation cut.

5. (Withdrawn) The gusset structure according to claim 4,
wherein

the cut-out strip comprises rounded corners.

6. (Currently Amended) A method for producing a gusset structure ~~according to claim 1,~~

wherein

the following method-related steps comprise:

- a) Cutting open a ~~[[the]]~~ first hollow section along its circumference except for a web situated in a ~~[[the]]~~ flat side;
- b) Bending up the first hollow section, which has been partly cut open, around the web positioned in the flat side in a way to form facing ends of the first hollow section and a bending angle;
- c) Inserting the second hollow section into the facing ends of the first hollow section, which ends have resulted from being cut and bent up so that the inserted second hollow section forms together with parts of the first hollow section a Y-shaped gusset; and
- d) ~~Integrally connection~~ connecting of the second hollow section with the first hollow section at its edge regions.

7. (Currently Amended) The method according to claim 6,

wherein

before it is cut open, the first hollow section is given an outward bulge around part of its circumference, and in that ~~the~~ a separating cut is made through the middle of said outward bulge.

8. (Previously Amended) The method according to claim 7,

wherein

the outward bulge is made in the first hollow section by interior high-pressure metal forming.

9. (Previously Amended) The method according to claim 6,
wherein
the cutting open of the first hollow section takes place by laser beam cutting.
10. (Previously Amended) The method according to claim 6,
wherein
the hollow sections are connected by welding or soldering.
11. (Previously Amended) The method according to claim 10,
wherein
welding or soldering is carried out using laser beam technology.